

Date: Tuesday, 09/09/2008 1:00:35 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STRUT WELDMENT ASS'Y
 Job Number : 41913
 Estimate Number : 10554
 P.O. Number :
 This Issue : 09/09/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D34431
 Drawing Number : D3443 REVB
 Project Number : N/A
 First Issue : / / Type : MACHINED PARTS Drawing Revision : B
 Previous Run : 41693 Material :
 Due Date : 30/09/2008 Qty: 20 Um: Each
 Written By :
 Checked & Approved By : JUD 08.9.09
 Comment : A 05.11.14 New issue EC
 Est Rev: B Removed Tumbling 08-09-08 JLM Verified By: EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M174B2500X1250 17-4 SS BAR 2.500 x 1.250



Comment: Qty.: 0.2100 f(s)/Unit Total: 1.6800 f(s)
 Material: 17-4 SS Bar 2.500" X 1.250"
 (M17-4-B2.500x01.250)
 Batch: M 101422

Rd 08/09/12

(20)

2.0 BAND SAW BAND SAW



Comment: BAND SAW
 Cut blank 2.400 " long

gmh 08/09/11

20

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA587 Rev: 12 & Dwg D3443 Rev: 12

M.A 08/09/13

Rd 08/09/12

(20)

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M.A 08/09/13

(20)

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

gmh 08/09/15

(20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 09/09/2008 1:00:36 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT WELDMENT ASS'Y

Job Number: 41913

Part Number: D34431

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

5782 93 *P-8/8/15* *(20)*

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D3065-5DART AEROSPACE LTD		Work Order: 41913
Description: Lug		Part Number: D3443-1
Inspection Dwg: D3443	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

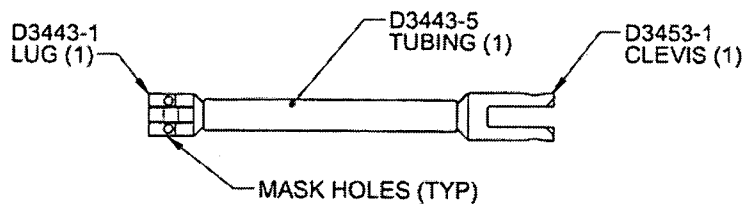
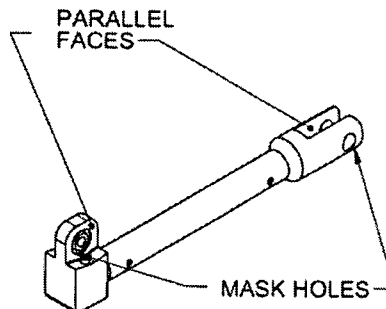
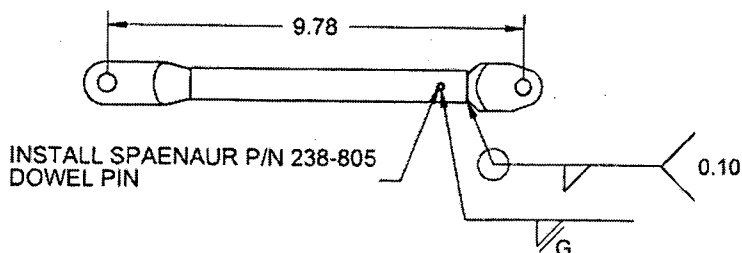
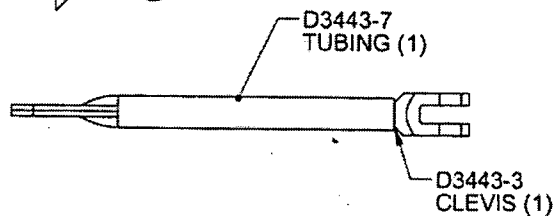
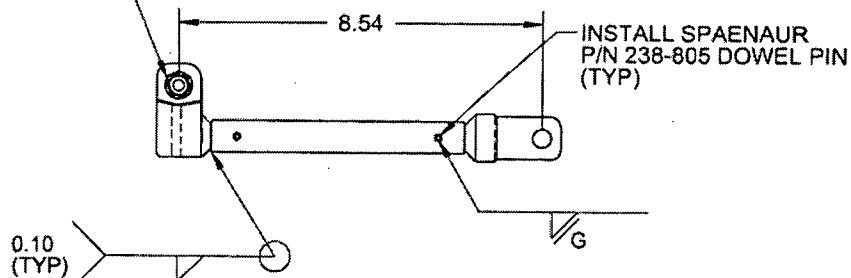
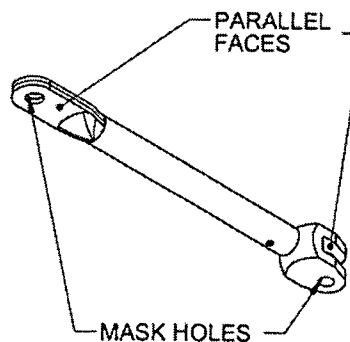
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.000	+/-0.010	1.000	✓			
0.342	+0.000/-0.005	0.3420	✓			
0.329	+/-0.010	0.327	✓			
Ø0.500	+0.000/-0.005	0.499	✓			
2.21	+/-0.030	2.216	✓			
Ø0.656	+0.000/-0.001	Ø0.6555	✓			
0.625	+/-0.010	0.630				
0.95	+/-0.030	0.953	✓			
2.230	+/-0.010	2.227	✓			
0.229	+/-0.010	0.229	✓			
0.370	+/-0.010	0.3675	✓			
0.525	+/-0.010	0.525	✓			
0.524	+/-0.010	0.526	✓			
0.390	+/-0.010	0.389	✓			
1.048	+/-0.010	1.045	✓			
0.05 x 45°	+/-0.5°	0.051 x 45°	✓			
R0.032	+/-0.010	R0.032	✓			
0.470	+/-0.010	0.472	✓			
0.165	+/-0.010	0.164	✓			
1/4-28UNF	N/A	1/4-28 UNF	✓			

Measured by: H.A	Audited by: [Signature]	Prototype Approval:	N/A
Date: 08/09/13	Date: 08/09/13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.07.11	New Issue	KJ/JLM [Signature]	[Signature]

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3443	REV. B SHEET 1 OF 3
DATE 05.12.05	TITLE STRUT WELDMENT ASSEMBLY 1:4		
A	05.09.02	NEW ISSUE	
B	05.12.05	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE; & $\phi 0.125$ WAS #30	

RELEASED05.12.09 *[Signature]*PRESS FIT McMASTER-CARR P/N 63215K32
BALL JOINT BEARING AFTER POWDER COAT**D3443-041****D3443-043****NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

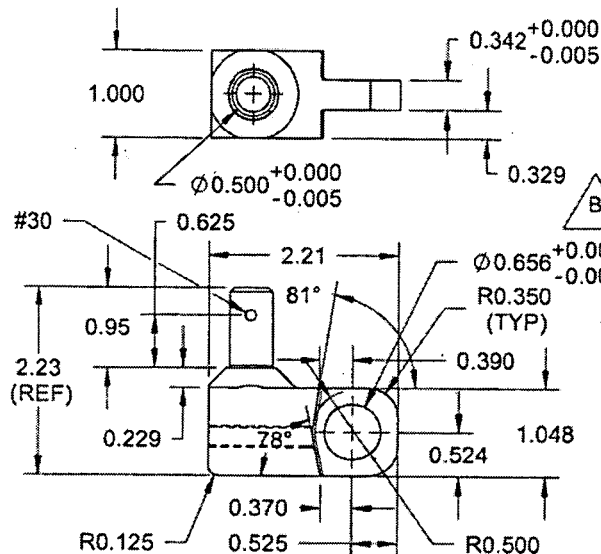
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DATE 05.12.05		TITLE STRUT WELDMENT ASSEMBLY	SHEET 2 OF 3 SCALE 1:2



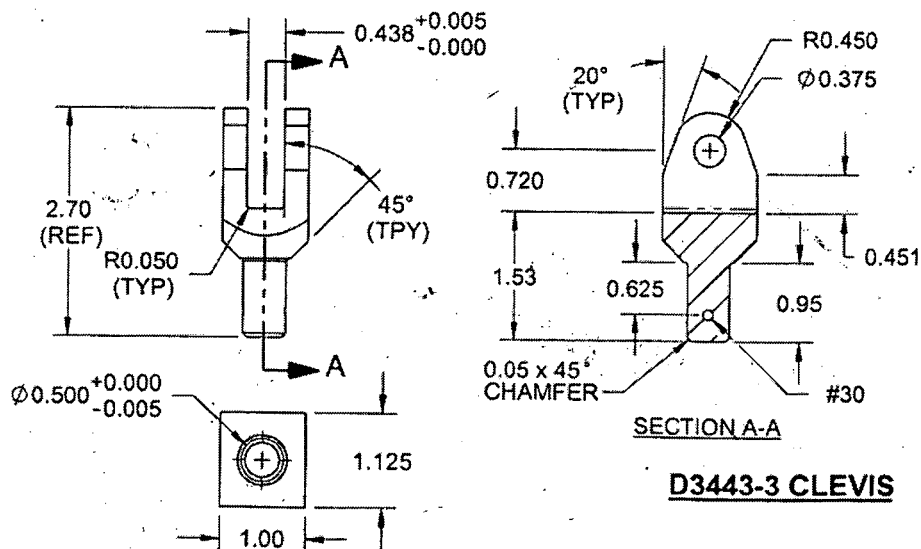
RELEASED

05.12.04

D3443-1 LUG

D3443-1 NOTES:

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)



D3443-3 CLEVIS

D3443-3 NOTES:

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)

GENERAL NOTES:

- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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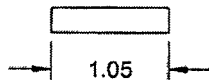
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CHECKED #	APPROVED #	DRAWING NO. D3443	REV. B SHEET 3 OF 3
DATE 05.12.05	TITLE STRUT WELDMENT ASSEMBLY 1:2		

$\phi 0.210^{+0.005}_{-0.010}$



D3443-9 PIN

D3443-9 NOTES:

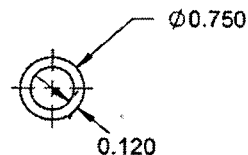
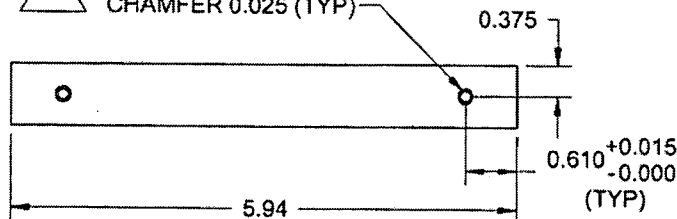
- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAIL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED

05.12.09

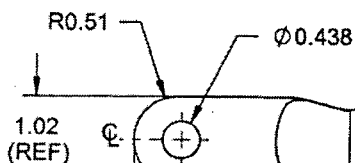
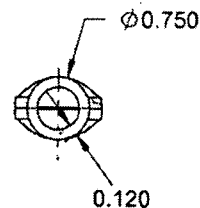


DRILL $\phi 0.125$ THRU
CHAMFER 0.025 (TYP)

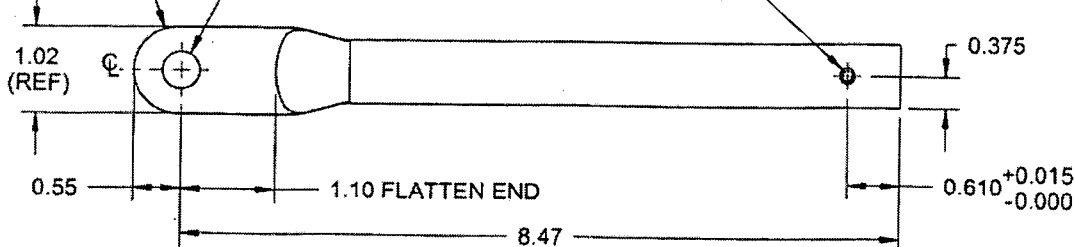


D3443-5 TUBING

$0.260^{+0.000}_{-0.030}$



DRILL $\phi 0.125$ THRU
CHAMFER 0.025



D3443-7 TUBING

D3443-5/-7 NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.7500W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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